

Work Order ID 70391

Monday, June 06, 2011 3:59:03 PM



Page 1

Item ID: D3584-1

Accept



Setup Start



Revision ID:

Item Name: Web

Stop



Start Date: 6/6/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 6/7/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 11-06-06

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3584

Rev A

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut to Length as per Dwg D3584
2-Drill Pilot Holes using DT8960 Drill Jig
3-Open pilots to 1.000" as per Dwg D3584
4-Deburr

3

B 11/06/07

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

B 11-6-7 (3)

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

B 11/06/07 (3)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70391

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Page 2

Item ID: D3584-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Web

Start Date: 6/6/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/7/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DP 11-6-7 (3)

140

Identify as per dwg & Stock Location: LC

0.00



Packaging

Memo

0.00

Packaging

(3) 11/06/07

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/8 JF

C21106107

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 06, 2011 3:58:56 PM

Page 1

Work Order ID: 70391

Parent Item: D3584-1

Parent Item Name: Web




Start Date: 6/6/2011

Required Date: 6/7/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07.06.12 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty. Issued	Date Issued	Status
D2963-125  105 I Beam Extrusion		Manufactured	No			110	Each	127.0000	1	2			

Location

Loc Qty

Loc Code

HALL

127

27775

18

28673

109

(3)

11/06/07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

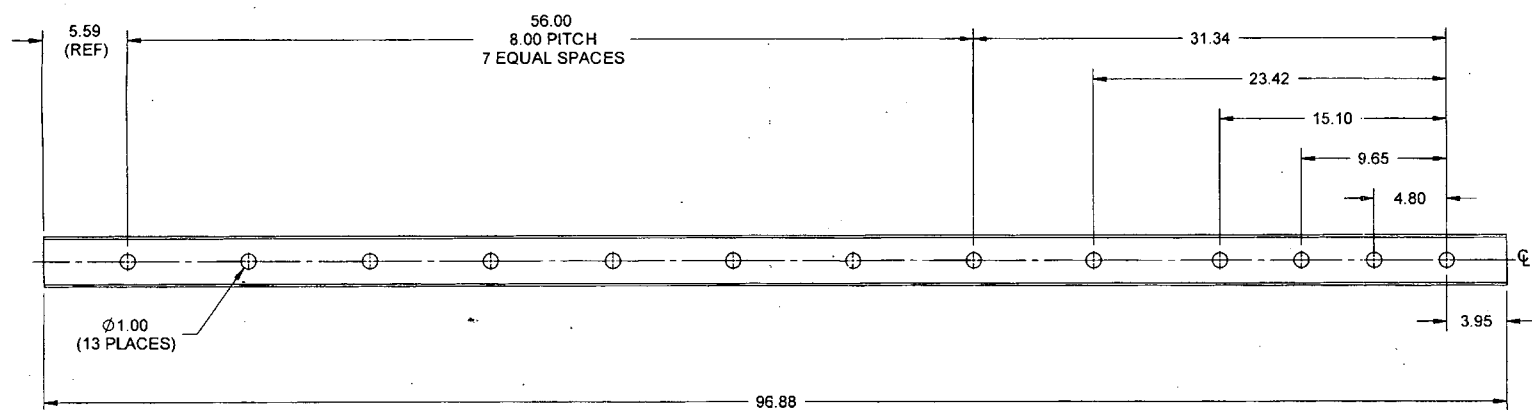
C

B

B

A

A



D3584-1 WEB

470391

RELEASED
07.11.22

- NOTES:
- 1) MATERIAL: MAKE FROM D2963-125 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.010 TO 0.020
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 5.08 lbs

A		NEW ISSUE		PH	07.06.08
REV.		DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWN	PH				
CHECKED	PH	DRAWING NO. D3584			REV. A
MFG. APPR.	PH	TITLE WEB			SHEET 1 OF 1
APPROVED	PH				SCALE 1:8
DE APPR.	PH				
DATE	07.06.08				

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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES						
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